Qty:

20 Um:

Each

Date: User:

Tuesday, 12/05/2009 2:07:08 PM

Melanie Fauteux

#### **Process Sheet**

**Drawing Name** 

**Part Number** 

Material **Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

: 47923

Job Number **Estimate Number** : 12412

P.O. Number

: 12/05/2009 This Issue

: NC Prsht Rev.

: // First Issue

: 38233 **Previous Run** 

Written By

Checked & Approved By

Comment : Est Rev:A New Issue 06-05-10 JLM

Est Rev:B ECN 1060 07-11-12 DD verified by:EC

: MACHINED PARTS

**Additional Product** 

Job Number:



Seq. #:

1.0

**Machine Or Operation:** 

MDELRINR12500



Comment: Qty.:

0.0546 f(s)/Unit Total

Material: Ø1.25 Delrin Rod

(M-DELRIN-R1.2500)Identify as D3121-25 M110256

HARDINGE 2.0

DELRIN ROUND BAR 1.25

Description:

: BEARING CAP

: D312125 : D3121 REV E

: 15/05/2009

: N/A

: E

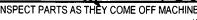


Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

3.0 QC2



PARTS AS THEY COME OFF MACHINE

Comment: INSPECT

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1



Identify and Stock









Comment: PACKAGING RESOURCE #1

09/05/14

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category: NC	R: Yes	No <b>DQ</b>	<b>\</b> :	Date: _	

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial   Action Description   Sign & Section C   Chief Eng   Date   Chief Eng   Chief E	Approval Chief Eng	Approval QC Inspecto			
		•						
								:

NOTE: Date & initial all entries

Date:

Tuesday, 12/05/2009 2:07:08 PM

User:

Melanie Fauteux

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING CAP

Job Number: 47923

Part Number: D312125

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



mE 09-05-14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHA	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr  Appro QC Insp	oval ector
			į				
							,
Part No	:	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date:	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Description of NC Corrective Action Section B		Verification	Annroyal	Annuarial		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
						!			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	17923
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121 Rev: E		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	
---	---------------	-----------	--

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.315	+/-0.010	.310				
Ø1.000	+/-0.010	0,1000				
Ø0.838	+/-0.002	0.837/				
R0.063	+/-0.010	R.063	//			
R0.010	+/-0.010	3,010				
0.230	+/-0.001	, 222	//			
Ø0.865	+/-0.001	0,865	1			
						1300

Measured by:	Audited by:	and.	Prototype Approval:	N/A
Date: 0%/05///	Date:	09/05/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
В	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM 1.A	
С	08.01.16	Dwg Rev. updated	KJ/EC/DD	Z

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			1						

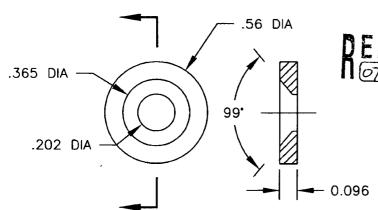
Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification Approval	Annuara	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

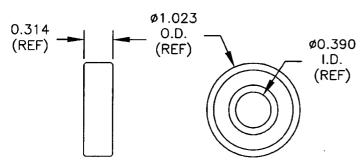


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED /	DRAWING NO.	REV. E
#	<del>    </del>	D3121	SHEET 10 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1



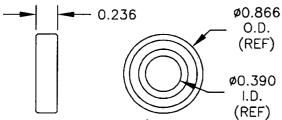
#### D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHÉS



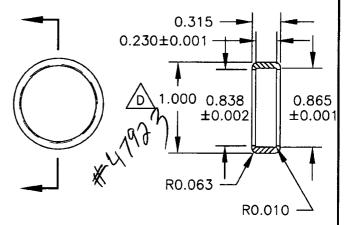
#### D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

# 0.375 TAP 10-32 UNF-3A 0.080 0.050 TO 0.060

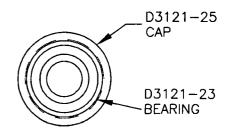
#### D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25
  (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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